

Date: Wednesday, 6/28/2006 4:17:38 PM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |                  |                             |
|-----------------------|---------------------------------------|------------------|-----------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : BO 105 SKID TUBE 'I' BEAM |
| Job Number            | : 27742                               |                  |                             |
| Estimate Number       | : 11075                               |                  |                             |
| P.O. Number           | : N/A                                 | Part Number      | : D2976                     |
| This Issue            | : 6/28/2006 S.O. No. : N/A            | Drawing Number   | : D2976 REV A1              |
| Prsht Rev.            | : NC                                  | Project Number   | : N/A                       |
| First Issue           | : N/A Type : LANDING GEAR             | Drawing Revision | : A1                        |
| Previous Run          | : N/A                                 | Material         | : N/A                       |
| Written By            | : <u>See Comment Below</u>            | Due Date         | : 7/15/2006 Qty: 6 Um: Each |
| Checked & Approved By | : <u>06 06 29</u>                     |                  |                             |
| Comment               | : Est. C 02.10.30 Re-format KJ        |                  |                             |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |          |                      |
|-----|----------|----------------------|
| 1.0 | D2963084 | 105 I Beam Extrusion |
|-----|----------|----------------------|



Comment: Qty: 4:5938 Each(s)/Unit Total: 27.5625 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2963-084 Extrusion

B4459 DP 6-7-13 06-07-13

|     |                |                         |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

Cut D2963-084 extrusion to length: (82.00")

Use Jig DT8546 to drill pilot holes

Open holes to finish size per dwg D2976

Deburr

DP 6-7-10 06-07-13

|     |                 |                            |
|-----|-----------------|----------------------------|
| 3.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

85 06-07-14

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

DP 6-7-17 06-07-13

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

LG DP 6-2-12 06-07-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 4:17:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BO 105 SKID TUBE 'I' BEAM

Job Number: 27742

Part Number: D2976

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Bo 06.07.18*

Job Completion



*u 06.07.18*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

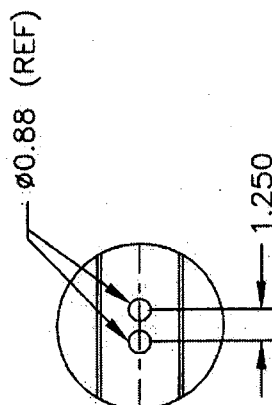
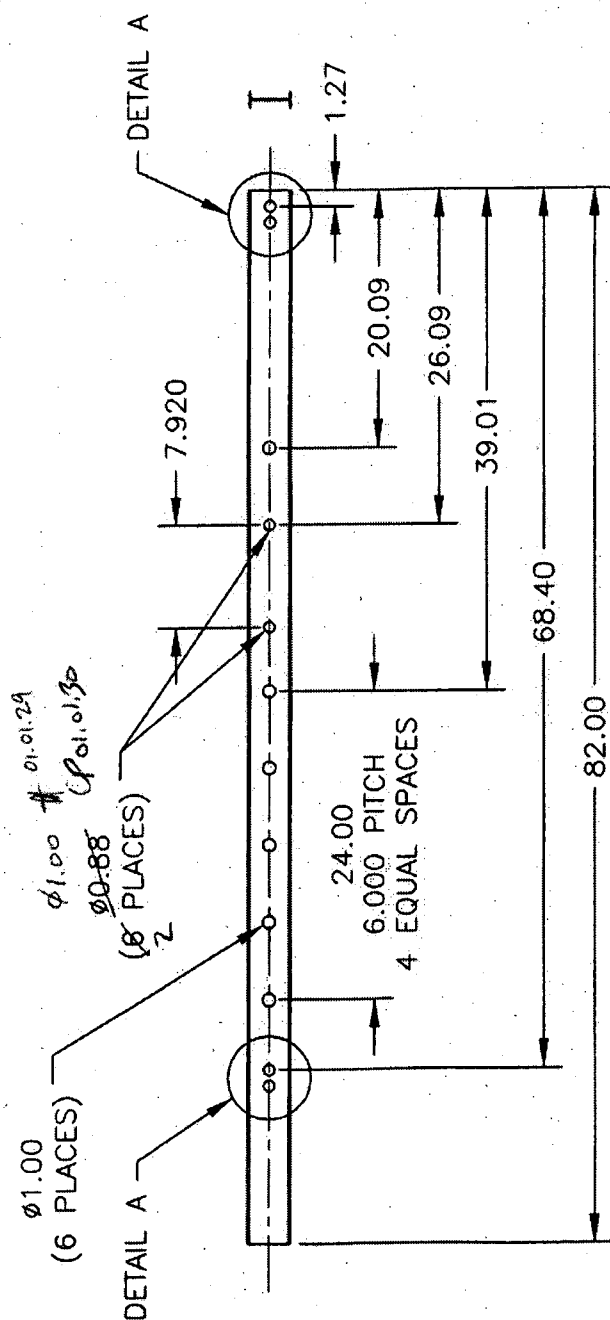
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



|                  |          |   |  |  |                        |
|------------------|----------|---|--|--|------------------------|
| DESIGN<br>RF     |          | DRAWN BY<br>RF                            |  | DART AEROSPACE USA, INC.<br>BELLEVUE, WA |                        |
| CHECKED<br>#     |          | APPROVED<br>#                             |  | DRAWING NO.<br>D2976                     | REV. A<br>SHEET 1 OF 1 |
| DATE<br>00.03.14 |          | TITLE<br>WEB                              |  | SCALE<br>1:14                            |                        |
| A                | 00.03.14 | NEW ISSUE                                 |  |  |                        |
| AI               | 01.01.29 | OPEN GROUND HANDLING HOLES TO $\phi 1.00$ |  |  |                        |

RELEASED  
00.05.11



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27742

MAKE FROM D2963-084 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

